



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3204-041
Job Sheet 172255



Part No: D3204-041

Job Qty: 2 ea

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/14/18

Job Tracking No:

Due Date: 3/9/18

Created By: Michelle Gagnon-Donovan

Type: **SOLD**

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/8/18	3/8/18	0.00	0.00	Start Up Large Fab-1		<i>12</i>
100	Large Fab	2 pcs	3/8/18	3/8/18	0.00	2.60	Large Fab 8		<i>12</i>
110	QC	2 pcs	3/8/18	3/8/18	0.00	0.00	QC9		<i>18.4.3 PD</i>
120	QC	2 pcs	3/8/18	3/8/18	0.00	0.00	QC5		<i>18.4.3 PD</i>
130	HandFinish	2 pcs	3/8/18	3/8/18	0.00	0.19	HandFinish1		<i>SA 18-01-03</i>
140	Powdercoat	2 pcs	3/8/18	3/8/18	0.00	0.15	Powdercoat3		<i>SA 18-01-03</i>
150	QC	2 pcs	3/8/18	3/8/18	0.00	0.00	QC3		<i>SA 18-01-03</i>
160	Small Fab	2 pcs	3/9/18	3/9/18	0.00	0.13	Small Fab-3		<i>SA 18-01-03</i>
170	QC	2 pcs	3/9/18	3/9/18	0.00	0.00	QC5		<i>SA 18-01-03</i>
180	Packaging	2 pcs	3/9/18	3/9/18	0.00	0.00	Packaging3-1		<i>SA 18-01-03</i>
190	QC21-SA	2 Ea	3/9/18	3/9/18	0.00	0.00	QC21		<i>SA 18-01-03</i>

Part Op 100 - 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding. 2- Place parts D3204-1,3,5,13 in jig Descriptions: number DT10295 for tacking parts together.3- Remove part from jig and install spacing rods to 6" inside of D3204-3 and D3204-5; weld parts then after parts have cooled; remove spacing rods...4- Inside measurement should be @ 5.9". Then proceed to installing D3204-11 plate, then D3204-9 pedal.5- Fill #30 hole when parts are cooled to room temperature quickly at around 150 amps... *1:35*

140 - ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE: *320°* FINISH TIME: *2:05*

180 - LOCATION : GA *M B6370*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3204-1	Tube	2 Ea (1 ea)	90-Start up Operation	
D3204-11	Plate	2 Ea (1 ea)	90-Start up Operation	
D3204-13	Gusset	4 Ea (2 ea)	90-Start up Operation	
D3204-3	Arm	2 Ea (1 ea)	90-Start up Operation	
D3204-5	Arm	2 Ea (1 ea)	90-Start up Operation	
D3204-9	Pedal	2 Ea (1 ea)	90-Start up Operation	
D3204-7	Bushing	4 Ea (2 ea)	160-Small Fab	<i>5043798</i>



Container No: S056639



Part: D3204-041

Job No: 172255

Serial No/Batch: S056639

Revision:

Inspector:

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Date: 03/29/18

Master Unit 001529



Job No 172255

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3204-1	2	21	0
	D3204-11	2	6	0
	D3204-13	4	0	0
	D3204-3	2	6	0
	D3204-5	2	3	0
	D3204-9	2	0	0
160-Small Fab	D3204-7	4	23	0
Part Specifications				
Specifications could not be found.				

Plex 2/14/18 1:41 PM Dart.Gagnon.Michelle